

Date: Wednesday, 26/11/2008 12:46:38 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL
 Job Number : 43767
 Estimate Number : 10765
 P.O. Number :
 This Issue : 26/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : *Small med Fab*
 Previous Run : 35658
 Part Number : D32451
 Drawing Number : D3245 REVB
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 03/12/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : *JO 08.11.26*
 Comment : Est. A 04.07.07 New issue KJ/JLM
 Est Rev:b ECN 1052 07-10-31 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.8442 sf(s)/Unit Total : 3.3768 sf(s)

304/316 .032 Sheet

Batch: *109057 IB 8-12-9*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245 ****prog.D3245-1/-2****

Dwg Rev: *B*

Prog Rev: *B*

IB 8-12-9

2-Deburr if necessary

IB 8-12-9

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-12-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/12/10

(4)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

~~Deburr if necessary~~

C'sink as per Dwg D3245

Form D3245-1 as per Dwg D3245 Identify as D3245-1

09/02/27 (4)
SB 09/02/25

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 43767

Part Number: D32451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/03/02 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

509/03/02 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02 (4)

Job Completion



U 09.03.02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43767
Description: Doubler		Part Number: D3245-1
Inspection Dwg: D3245	Rev: B	Page 1 of 1

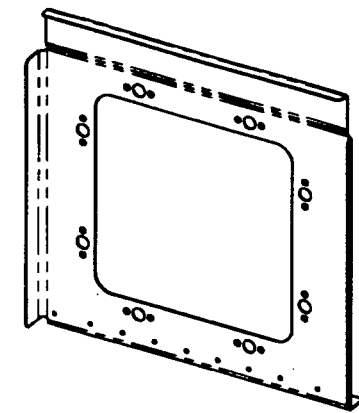
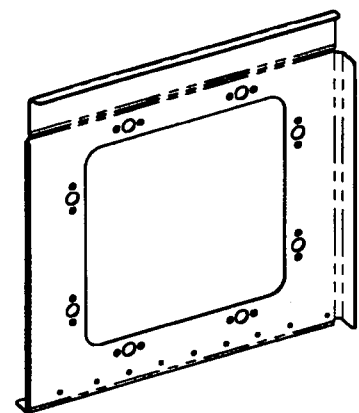
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

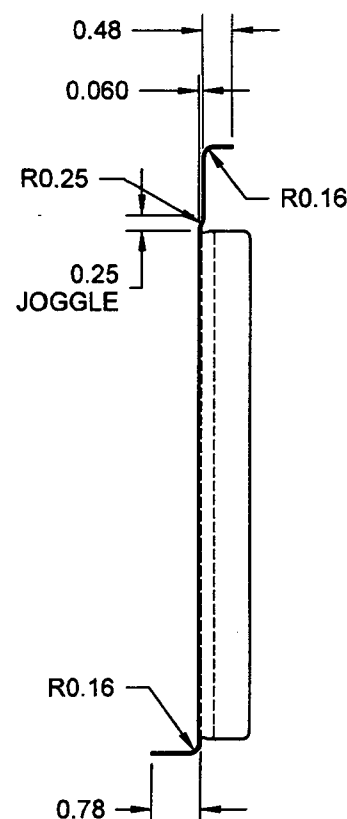
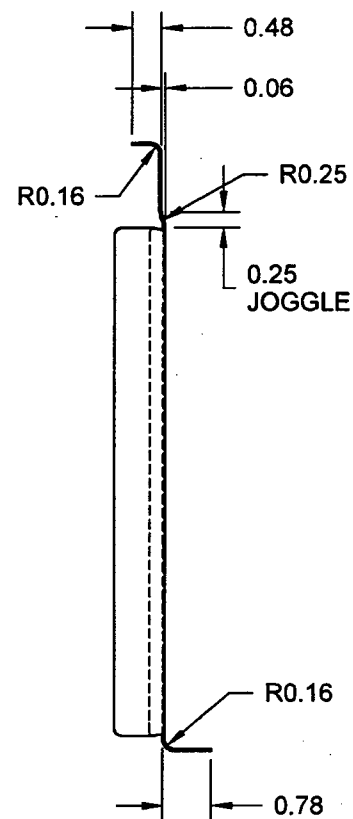
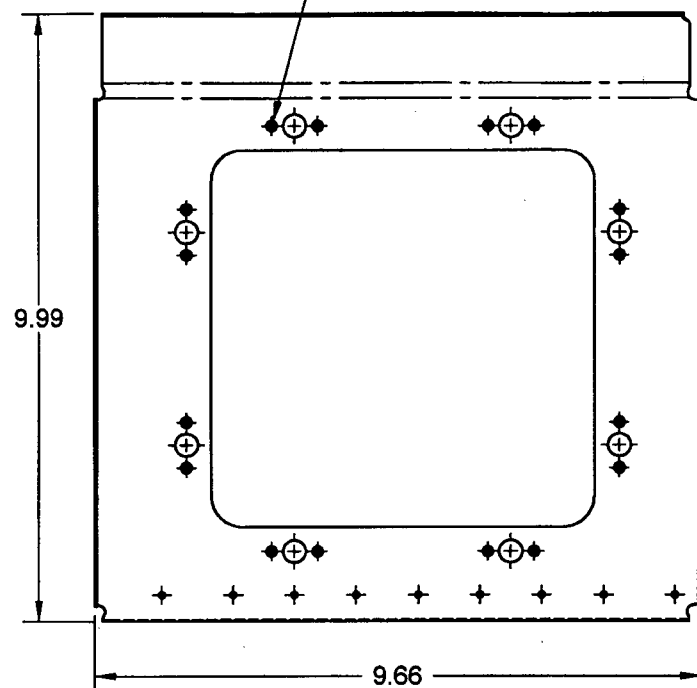
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	<input checked="" type="checkbox"/>			
Ø0.375	+0.006/-0.001	.376	<input checked="" type="checkbox"/>			
0.400	+/-0.010	.400	<input checked="" type="checkbox"/>			
1.117	+/-0.010	1.120	<input checked="" type="checkbox"/>			
1.150	+/-0.010	1.147	<input checked="" type="checkbox"/>			
1.000	+/-0.010	.998	<input checked="" type="checkbox"/>			
10.57	+/-0.030	10.567	<input checked="" type="checkbox"/>			
9.500	+/-0.010	9.498	<input checked="" type="checkbox"/>			
8.350	+/-0.010	8.348	<input checked="" type="checkbox"/>			
3.500	+/-0.010	3.498	<input checked="" type="checkbox"/>			
9.40	+/-0.030	9.398	<input checked="" type="checkbox"/>			
11.04	+/-0.030	11.038	<input checked="" type="checkbox"/>			
6.200	+/-0.010	6.195	<input checked="" type="checkbox"/>			
2.230	+/-0.010	2.233	<input checked="" type="checkbox"/>			
2.020	+/-0.010	2.024	<input checked="" type="checkbox"/>			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-12-9	Date: 08/12/10	Date:	N/A

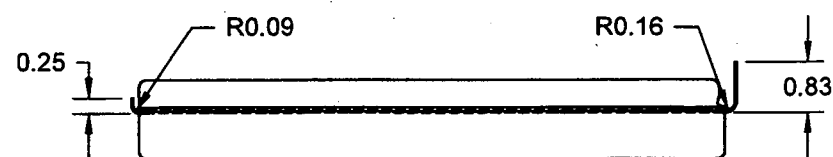
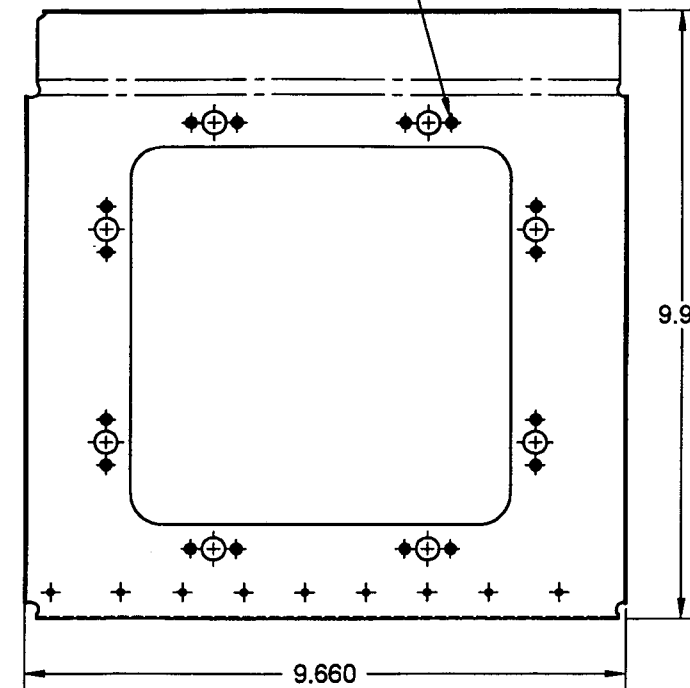
Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	DD



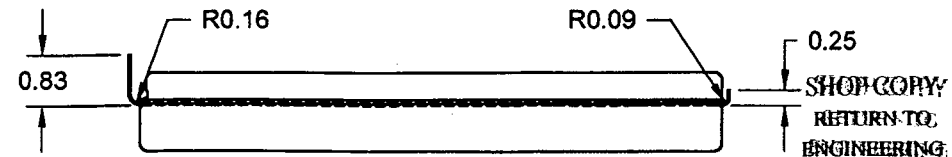
C'SINK $\phi 0.170 \times 100^\circ$
(16 PLACES)



C'SINK $\phi 0.170 \times 100^\circ$
(16 PLACES)



D3245-1 PANEL BEND DETAIL, LH



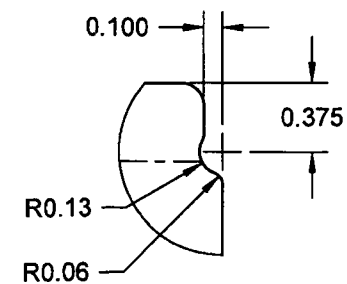
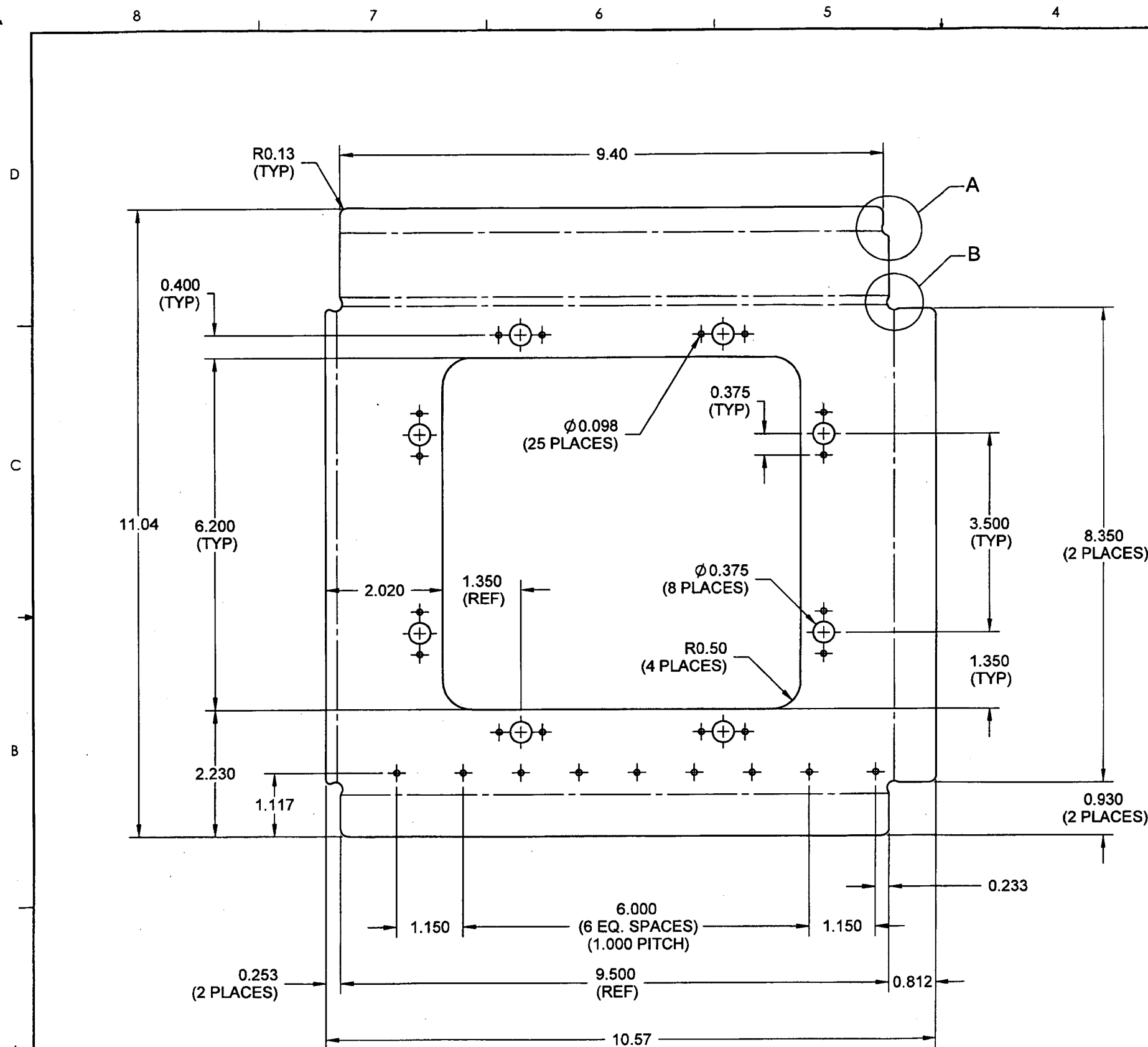
D3245-2 PANEL BEND DETAIL, RH

RELEASED
WP 07-10-23

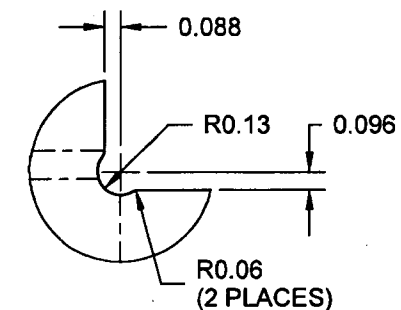
- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43767

DESIGN	7/1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	AD	TITLE	SCALE
DE APPR.	SH	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP, 4 PLACES)
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43267

RELEASED
11/01/02

D3245-1F PANEL FLAT PATTERN

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 4 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
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